

Work Order ID 76456

76456

Page 1

November-15-11 8:03:24 AM

Item ID: D407-802-018

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 11/11/15

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D407-802-1	A

100 DOCUMENT CONTROL 0.00

100

DC Memo 0.00

Document Control Photocopy bluefile and create labels per PPP D407-802-018 CHG001

S. Z. Lutz

M.C.J. 12/04/26

23

105 Pick Kit 0.00

105

Packaging Memo 0.00

Packaging

2x

SP

12-04-26

110 QC4- 100% Inspect kits for completeness 0.00

110

QC Memo 0.00

Quality Control

S. Z. Lutz

72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Revision ID:

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Start Date: 15/11/2011 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD407-802-018

Location:

PPP rev:

2x

12/12/11

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/04/30

MLJ 12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 76456

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Parent Item: D407-802-018

D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
10.12.03 as per dwg rev.A DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17		Manufactured	No			105	Each	23.0000	1	2			
D3552-17									**	SP			
Door Prop													

Location Loc Qty Loc Code

ST272 11

64338 4

65120 7

ST276 12

69670 12

D3622-5		Manufactured	No			105	Each	12.0000	1	2			
D3622-5									**	2x			
Ball Stud													

Location Loc Qty Loc Code

ST070 12

65087 12

D4108-3		Manufactured	No			105	Each	5.0000	1	2			
D4108-3									**	B 79351 SP			
Door Doubler, Right													

Location Loc Qty Loc Code

st128 5

62302 1

64485 4

12-04-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D407-802-018

D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

D4108-5 Manufactured No

105 Each 4.0000 1

D4108-5

Small Right Door Doubler

**

2
B79344 80

Location

Loc Qty

Loc Code

st128

4

62303

2

64486

2

D4108-11 Manufactured No

105 Each 6.0000 1

D4108-11

Template

**

2
B79297 80

Location

Loc Qty

Loc Code

st128

6

64488

6

D4108-047 Manufactured No

105 Each 1.0000 1

D4108-047

Sill Doubler Assembly

**

1X
2
B83779 80
B89352
12-04-27

Location

Loc Qty

Loc Code

ST129

1

64489

1

CR3523-4-02 Purchased No

105 Each 450.0000 19

CR3523-4-02

BIVET

**

38
8012-04-26

Location

Loc Qty

Loc Code

ST314

450

116391

100

116893

3

116915

1

117946

46

117978

200

118686

100

38x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D407-802-018

D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

CR3523-4-4

Purchased

No

105

Each

14.0000

4

8

CR3523-4-4

Rivet

**

m119717 sp. 12-04-26

Location

Loc Qty

Loc Code

ST314

14

115768

14

MS20426AD4-6

Purchased

No

105

Each

1,379.000

2

4

MS20426AD4-6

Rivet

**

JB

Location

Loc Qty

Loc Code

ST317

1379

110139

201

117505

178

119436

1000

MS21073L5

Purchased

No

105

Each

73.0000

1

2

MS21073L5

nut plate

**

119436 JB

Location

Loc Qty

Loc Code

ST302

73

117395

73

MS27039C1-27

Purchased

No

105

Each

35.0000

2

4

MS27039C1-27

Screw

**

117395 JB 12/04/25

Location

Loc Qty

Loc Code

ST293

35

115768

35

115768

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 76456

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Parent Item: D407-802-018

D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

105

Each

2,056.000

2

4

NAS1149C0332R

Washer

**

121509 JB

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2049

116304

55

117460

18

117887

169

118078

2

118179

78

118354

987

119124

740

NAS1149C1165R

Purchased

No

105

Each

85.0000

2

4

NAS1149C1165R

Washer

**

JB

Location

Loc Qty

Loc Code

ST296

85

115768

85

115768

NAS1149C0532R

Purchased

No

105

Each

281.0000

6

12

NAS1149C0532R

WASHER

**

119736 JB

12/04/25

Location

Loc Qty

Loc Code

ST297

281

116373

1

116513

53

118384

227

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D407-802-018

D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0563R

Purchased

No

105

Each

370.0000

6

12

✓

NAS1149C0563R

Washer

**

JB 12/04/25

SZ

Location

Loc Qty

Loc Code

ST297

370

116391

182

117460

188

116391

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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REFERENCE ONLY

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5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: A
Date: 10.10.13